

SPLIT

Push

Work Order ID 64118-1

Wednesday, November 24, 2010 2:50:00 PM



Page 1

Item ID: D3859-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

(2)

Start Date: 11/25/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date: 10/11/10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



FLOW WATER JET

0.00

KB 10-11-2010

Waterjet

FLOW CNC Waterjet

304 663

Memo

0.00

I-Cut as per Dwg D3859 | Dwg Rev: A | Prog Rev: A | 2-
Deburr if necessary

(8)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

KB 10-11-2010

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

5000125

(78)

Work Order ID 64118

Wednesday, November 24, 2010 2:50:00 PM

Rusby



Page 2

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Required Date: 12/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Large Fab

0.00

10/11/25

2X

Large Fab

Large Fab

Memo

0.00

1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod
 Batch: M114649 2-Weld hard facing as per Dwg D3859 A/R
 2059B Hard Coat rod Batch: M116044 ****use
 DT9462 for welding****

→ EC 10-11-26 (X)

140



QC9- Inspect visual per QSI004- Fusion Welds

0.00

PQ 10.11.26

QC

Quality Control

Memo

0.00

(2X)

150



QC5- Inspect part completeness to step on W/O

0.00

S 10/11/26

QC

Quality Control

Memo

0.00

(X)

Work Order ID 64118

Wednesday, November 24, 2010 2:50:00 PM



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Item ID: D3859-041

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Item Name: Wearplate

Start Date: 11/25/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588.

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.
Stamp

2 BR 10-11-26

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/11/24

2 φ

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10/11/26 ②

Work Order ID 64118

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Wednesday, November 24, 2010 2:50:00 PM

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Start



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Start Date: 11/25/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

CK 10/11/29 AF
MF 10-11-26

Memo

0.00

Picklist Print

Page 1

Wednesday, November 24, 2010 2:49:59 PM

Work Order ID: 64118



Parent Item: D3859-041

Parent Item Name: Wearplate

Start Date: 11/25/2010

Required Date: 12/8/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	133.9000	0.85	6.8		1830-11-26	

304/316 Sheet .063

D3009-3



Cup

Location	Loc Qty	Loc Code
MAT	133.9	
111323	0	
115688	2.9	
115953	131	115953

130 Each 185.0000 6 48

EL 10-11-26

Location	Loc Qty	Loc Code
WA	185	
42377	185	12

DART AEROSPACE LTD	Work Order:	6413
Description: Wearplate	Part Number:	D3859-1
Inspection Dwg: D3859	Rev: A	Page 1 of 1

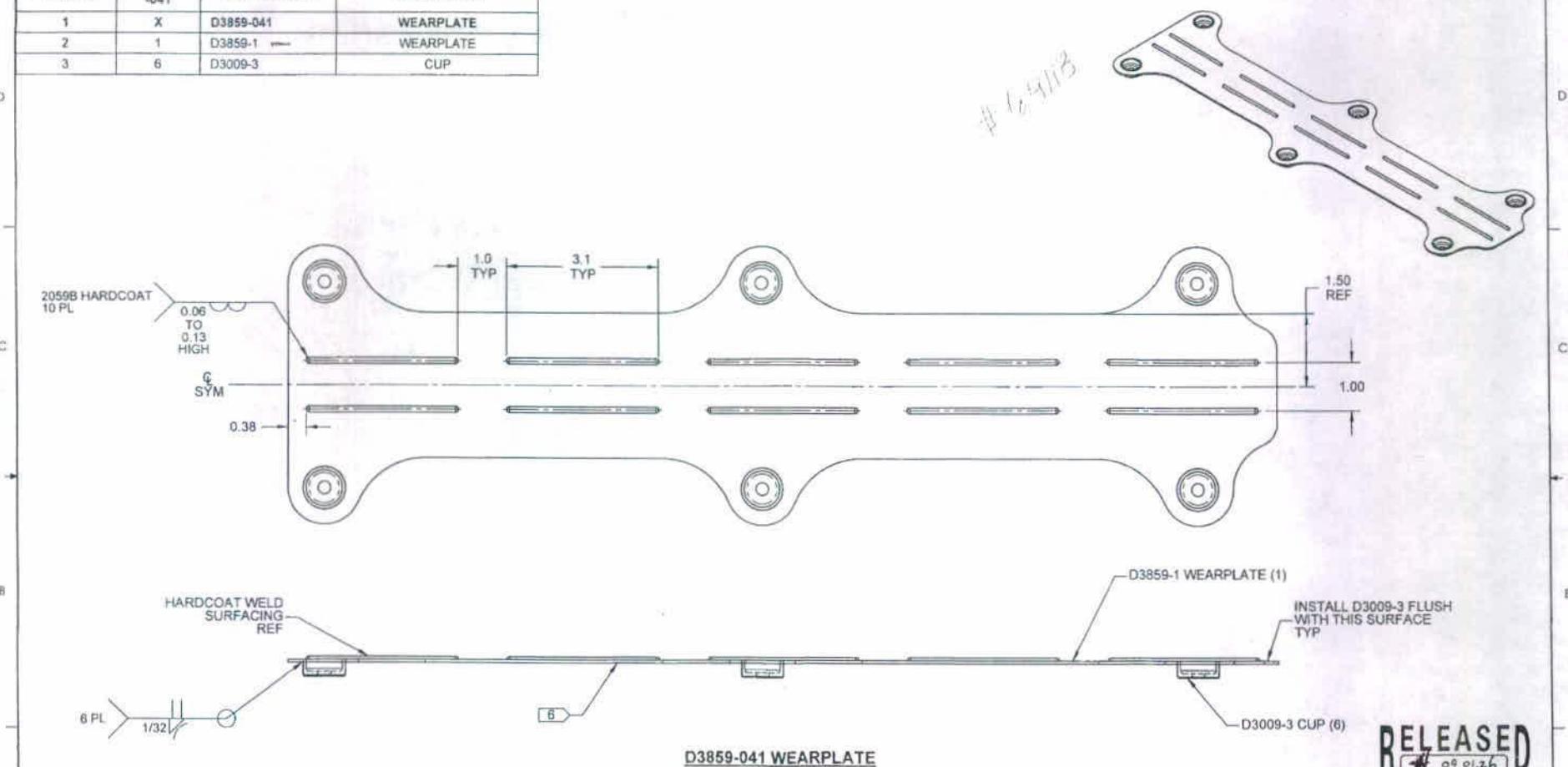
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>R</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-11-25</u>	Date: <u>10/4/25</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	P/O D3859-041	KJ

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

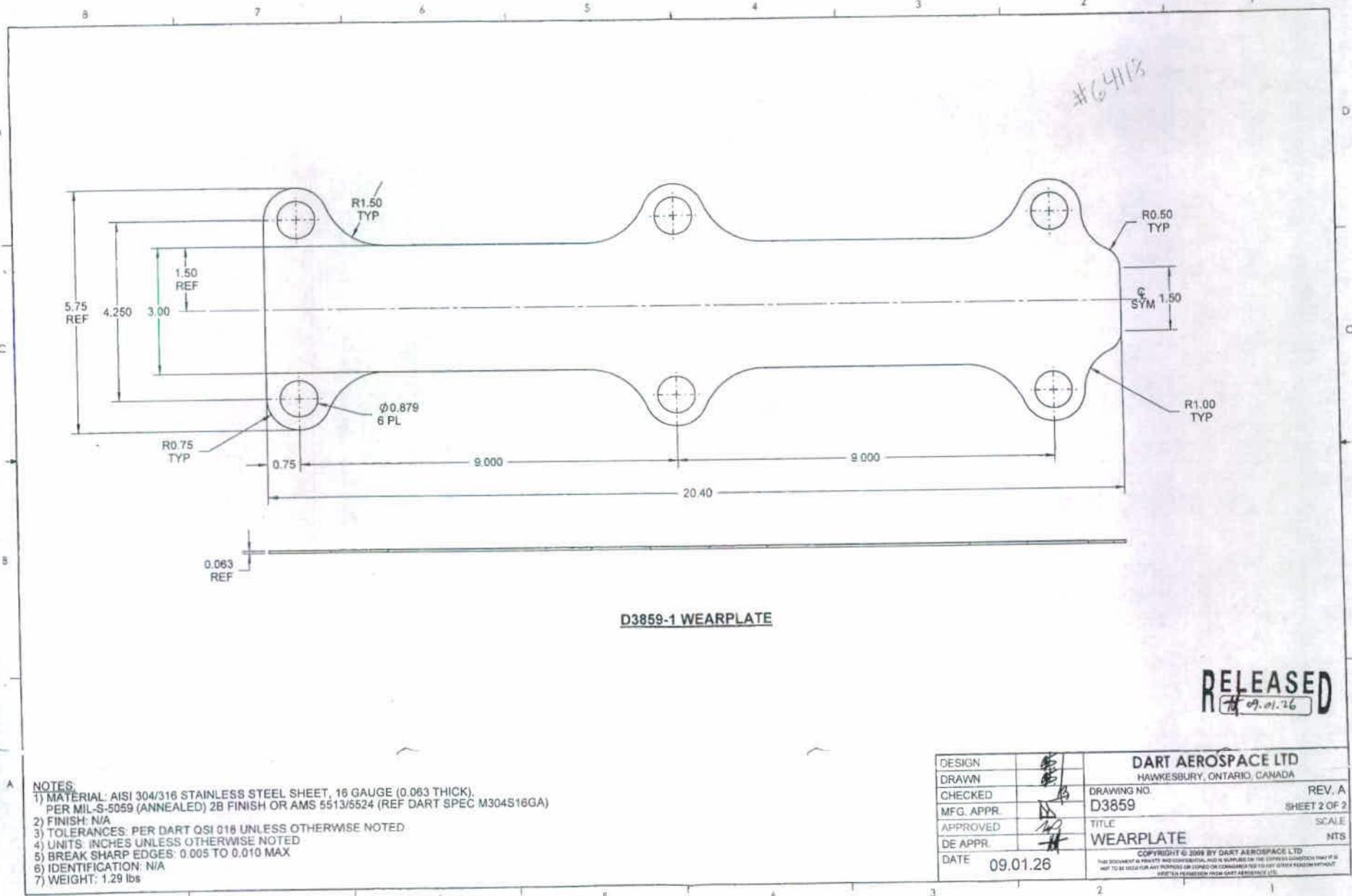


D3859-041 WEARPLATE

RELEASED
09.01.26

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.45 lbs
8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV	DESCRIPTION		BY DATE
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKSBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO.	REV. A	
MFG. APPR.	D3859	SHEET 1 OF 2	
APPROVED	TITLE	SCALE	
DE APPR.	WEARPLATE	NTS	
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK).
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. A	
MFG. APPR.		DRAWING NO.	
APPROVED		D3859	SHEET 2 OF 2
DE APPR.		TITLE	SCALE
DATE	09.01.26	WEARPLATE	NTS

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